Work Orde					108	3163	*						Page 1	
Item ID: Revision ID: Item Name:	D4130-9 Aft Cargo Flo	or Protector		Accept	Parameter of Param	*N9	nn	040	100)*	Setup Star	1/1	S1*	
Start Date: Required Date: Reference:	10/8/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*				Item lomer:	ID:				"N	S2*	
Approvals:			Date: 13-10-68					ate:			Run Star Stop		R1* R2*	
Sequence ID/ Work Center II)	Operation Description			Up/ I Hours	Too	ol ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr						· · · · · · · · · · · · · · · · · · ·						
D4130	В													
*100 *100* Waterjet FLOW CNC Waterje	et	FLOW WATER JET Memo 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if	3	0.00						6	0		Jm13-10	-09
110 *11 A*11 ** QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00						6	··· O		Jm13-10	P0 - c
120 *120* QC Quality Control		QC8- Inspect parts - seco	nd check	0.00	DAS 27 9-89). Q				6	·	v <u>.</u>	, <u>-</u>	

NCR: Y	·												
											QA Closed:	Dat	e:
Work Orde	ari.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part N	- ۱٥٠					Rework Scrap Use-as-is Work Order Update		f Therm	Machining S noforming	Crosstube Small Fab Finishing omposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
				r									
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance		Initial nief Eng	Action Description	on	Sign & Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator			ļ			•							
Material													
Setup			<u> </u>										
Other			Ī	1									
Process	Ш						İ						
Supplier	Щ												
Training													
Unapproved			<u> </u>										
						,	AUL	T CATE	GORY				
Landi	<u> </u>				·	General	_	1			1	г	_
		Bending				Bend	<u> </u>	Grain		—	Ovalized		Pressure/Forced
	_	Centre No	ot Concei	ntric to	o/s	BOM/Route	\vdash	Hardwa		 	Over/Under	i-	Temperature/Cure
	-	Cracks			-	Broken/Damaged	\vdash	4	on Incomplete	<u> </u>	Part Incorred		Weld
	_	Crushed/	Crimped			Burrs	\vdash	1	ions Incomplete/Uncle		Part Lost/Mi	ssing	Wrong Stock Pulled
	\vdash	Cuffs			1	Contamination	\vdash	Mainte		—	Part Moved	M	
	Ш	Heat Trea				Countersink	-	Mislabe			Positioned V		704h
	\vdash	Inspectio		Tube	-	Cut Too Short	-	Misread	I	L.	Power Loss/	ourge [Other
	\vdash	Ripples in			_	Drill Holes	-	Offset	Sa (ila maki a m				
1		Torque W	vaves in t	extrusio	n [Drawing	1	Jour of C	Calibration				

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish Folio

Work Order ID 108163

Tuesday, Octobe					*1()8	3163*							Page	e 2
Revision ID:	D4130-9			1	Accept	*N900	040	100)*	Setup	Start	*N	S1*	
Item Name:	Aft Cargo Flo	or Protector									Stop	*N	S2*	
Start Date: Required Date: Reference:	10/8/2013 10/11/2013	Start Qty: 6.00 Req'd Qty: 6.00		*6* *6*		Cust Item I Customer:	ID:							
Approvals:	Process Pla	n:	_ Date:_	, -	Tooling:	D:	ate:	_		Run	Start	*N	R1*	r
	QC:	- 4	_ Date:_		SPC (Y/N):		ate:				Stop		R2*	
Sequence ID/ Work Center ID)	Operation Description	andr I anatio		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
130 Packaging		Identify as per dwg & St Memo	•	168/40 168/60	0.00	,					13/13	/9	() 9	32 -89
*140 *14 0 *		QC21- Final Inspection -	- Work Orde	r Release	0.00					LA.	10	110	/X /	17)
QC Quality Control		Memo			0.00					10)	JJU-	0	10-1 MF 13-10	0°

DQA:	Date:	
		 _

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	-						•		QA Closed:	Date	:
Work Orde	o ř·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Work Orde					Rework	1 	Skid-tube	Crosstube]	Water Jet	Engineering
Part N	ło				Scrap]	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	The	ermoforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No				Work Order Update]	Large Fab	Composite	J	Supplier	
Root				Descri	ption of work order update	Initia	Α	ction	Sign &		
Cause	Date	e Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling						1				i I	
Operator											
Material			1								
Setup ,											
Other '		1	1								
Process											
Supplier											
Training		-									
Unapproved											
	•				F.	AULT CA	TEGORY				
Landi	ng Gear				General				_		<u></u>
	Bendir	ng			Bend	Grai	n		Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorre	ct	Weld
	Crushe	ed/Crimped	ļ		Burrs	Instr	uctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	ntenance		Part Moved		
	Heat T	reat			Countersink	Misl	abeled		Positioned V	Vrong	
	Inspec	tion Strip ii	n Tube		Cut Too Short	Misr	ead		Power Loss/	Surge	Other
	—	s in Bend			Drill Holes	Offs	et	<u>. </u>	•	<u> </u>	
	$oldsymbol{eta}$	e Waves in	Extrusio	n	Drawing	Out	of Calibration				
		g Sequence			Finish	-	of Sequence				
	\vdash	Twist in Tu			Teolio	Houte	ide Dimensions				

Picklist Print

Tuesday, October 08, 2013 9:18:43 AM

Work Order ID:

108163

Parent Item:

D4130-9

Parent Item Name:

Aft Cargo Floor Protector

Start Date: 10/8/2013

Required Date: 10/11/2013

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 10.06.08 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,471.4520	5.882	(42)			
GE PLASTICS LEXAN S	HEET											Jm	113-10-09

Location	Loc Qty	Loc Code	
MAT018	2471.452		
124866	286.792		
m126425	2184.66		136435

Page 1

NCR:													
		÷									QA Closed:	Date	:
Work Orde	er:					DISPOSITION	_			AGAINST DE	PARTMENT,		
Part N	-					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				[Descri	ption of work order update	Τ	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	C	hief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					,			LT CATE					
Landi						General	FAU	LT CATE	GURT				
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	st ssing /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1		Torque V	vaves in E	extrusio	n [Drawing	-	Out of 0	Calibration				·

Out of Sequence

Outside Dimensions

DQA:

Date:

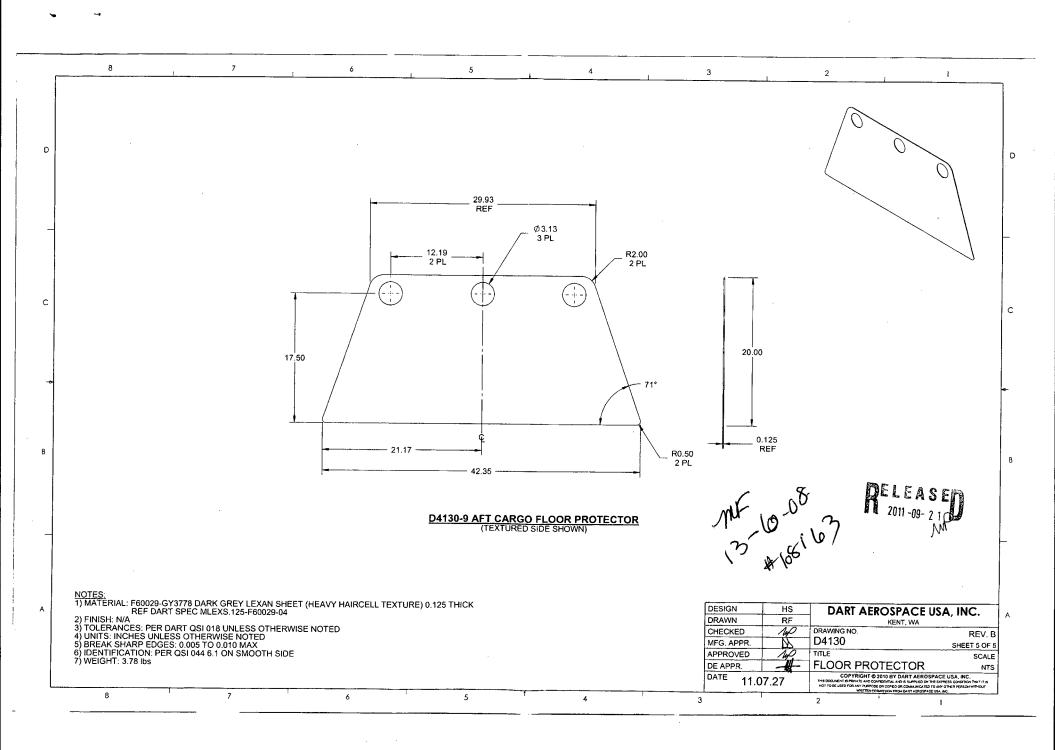
Turning Sequence

Wave/Twist in Tube

Finish

Folio

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											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER	NON-C	ONFORM	MANCE / UF	PDATE			
										"	QA Closed:	Date	
Work Ord	oř.					DISPOSITIO	N			AGAINST D	EPARTMENT	/PROCESS	
VVOIROIG	C1.					Rev	work		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part	No.						Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	,					Use-	-as-is	4	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR	No.	,		· · · · · · · · · · · · · · · · · · ·		Work Order Up	date		Large Fab	Composite _		Supplier	
Root					Descri	ption of work order u	pdate	Initial	Ad	ction	Sign &		
Cause		Date	Step	Qty	l .	or Non-conformance		Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	_						İ				ŀ		
Operator											1		
Material													·
Setup			}										
Other	L									,			,
Process				ļ			,						
Supplier													
Training													
Unapproved													
							FA	ULT CATE	GORY				
Land	ing (Gear				General	•						_
		Bending				Bend	[Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Γ	Cracks				Broken/Damaged		Inspect	ion Incomplete	. [Part Incorre	ct	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	108162		
Description: Aft Cargo Floor Protector	Part Number:	D4130-9		
Inspection Dwg: D4130 Rev: B		Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.13	+0.012/-0.001	3.133"	_		V	Jamo 1
12.19	+/-0.030	12.19"	_		7	Jiemo 6
29.93	+/-0.030	29.93"	_		7	SKWC 6
17.50	+/-0.030	17.50"	_		7	
21.17	+/-0.030	21.17"	_		7	
42.35	+/-0.030	42.35	-		一	
20.00	+/-0.030	20.00	_		T	
0.125	+/-0.010	0.136,				-
					-	
		·				
	*					

			DAS		
Measured by:	Jm	Audited by:	27	Preliminary Approval:	
Date:	13-10-09	Date:	130.9	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.10.25	New Issue	KJ IN	Approved
В	12.05.15	Dwg Rev updated	KJ W	711
			——————————————————————————————————————	G/4 11/

		DQA:	Date:	
NCR: Ves / No	WORK ORDER NON-CONFORMANCE / UPDATE			

NCR: Y	'es	/ No				WORK ORDER NON-C	CON	FORM	MANCE / UP	DAIL			•
					3						QA Closed:	Date:	
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other		
Root					Descri	ption of work order update	In	itial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Chie	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data							1						
Equip/Tooling	_												
Operator	_	İ											
Material	_												
Setup	_												
Other	4		·										
Process	_					•	İ						
Supplier	_										-	4.	
Training	4							;					
Unapproved							<u> </u>						
							AULI	CATE	GORY				
Landir ſ	_					General	<u></u>	Grain			Ovalized		Pressure/Forced
}	Bending				0/5	Bend DOM/Route	⊢ ——	arain Hardwa		-	Over/Under	talaranca	Temperature/Cure
}	Centre Not Concentric to O/S			itric to	^{0/8} -	BOM/Route Broken/Damaged	-				-		Weld
	Cracks					Burrs	-	Inspection Incomplete		Uncloar	-		Wrong Stock Pulled
	Crushed/Crimped Cuffs				-	Contamination	-	Instructions Incomplete/Unclear Maintenance			Part Moved	1551118	Twitolik Stock Lailed
,	Heat Treat				<u> </u>	Countersink		Mislabe			Positioned Wrong		
	Inspection Strip in Tube			Tuhe	<u> </u>	Cut Too Short	\vdash	Misread Power Loss/Surge				Other	
,				Drill Holes	\vdash	Offset	-	L	1. 0.1.0. 2033/		1		
	-			xtrusio	n	Drawing	-		Calibration				
	Torque Waves in Extrusion Turning Sequence				·	Finish	-		Sequence			···	

Outside Dimensions

Wave/Twist in Tube

Folio

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